

Date: Tuesday, 22/04/2008 3:53:16 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE, INBOARD, RS, 206
Job Number :	38752		
Estimate Number :	10821		
P.O. Number :		Part Number :	D26662
This Issue :	22/04/2008	Drawing Number :	D2666 REV.D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	D
Previous Run :	37333	Material :	
Written By :		Due Date :	10/05/2008
Checked & Approved By :	JLD 08.4.23	Qty:	12 Um: Each
Comment :	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: B34872 DTP 08/06/17

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 3-Fixturing Inspection last completed on 08/06/17 by DTP
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 7- Deburr

DTP 08/06/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

DTP 08/06/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:16 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 38752

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/06/18

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 08/06/19

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/06/20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/107925

FX 08/06/23

(12)

(P10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/06/24

(12X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *426*

08/06/27

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



08/06/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/06/23	7.0	Start time: 10:35 Temp: 320° Finish time: 11:05	FZ	08/06/23	12			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 38750
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.118	0.116	0.116	0.117		
B	0.100	0.140		0.120	0.120	0.121	0.121		
C	2.470	2.510		2.503	2.501	2.501	2.502		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.220	0.220	0.220	0.220		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.240	0.260		0.2505	0.249	0.248	0.250		
H	0.615	0.685		0.645	0.645	0.645	0.645		
I	1.125	1.145		1.1335	1.1345	1.136	1.1335		
J	0.990	1.010		0.999	0.998	0.999	0.998		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.110	0.110	0.110	0.110		
N	1.565	1.585		1.570	1.572	1.573	1.571		
O	5.990	6.010		6.002	6.000	6.000	6.000		
P	1.245	1.255		1.248	1.249	1.249	1.249		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.498	0.499	0.499	0.501		
S	0.313	0.318		0.3155	0.3155	0.3155	0.3155		
T	2.495	2.505		2.499	2.500	2.499	2.500		
U	1.357	1.367		1.360	1.360	1.362	1.362		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.544	0.548	0.545	0.546		
X	1.674	1.684		1.678	1.678	1.679	1.678		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP
Date: 08/06/17

Audited by: JF
Date: 08/06/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 38758
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		0.117	0.119	0.118	0.117		
B	0.100	0.140		0.120	0.121	0.120	0.121		
C	2.470	2.510		2.501	2.501	2.501	2.501		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.220	0.220	0.220	0.220		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.240	0.260		0.249	0.250	0.249	0.249		
H	0.615	0.685		0.646	0.646	0.646	0.645		
I	1.125	1.145		1.133	1.136	1.135	1.136		
J	0.990	1.010		0.998	0.998	0.998	0.998		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.110	0.110	0.110	0.110		
N	1.565	1.585		1.571	1.573	1.571	1.574		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.249	1.250	1.250		
Q	2.495	2.505		2.498	2.499	2.500	2.499		
R	0.490	0.510		0.502	0.503	0.504	0.506		
S	0.313	0.318		0.316	0.315	0.315	0.315		
T	2.495	2.505		2.500	2.500	2.499	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.363		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.545	0.545	0.547	0.547		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DTJ
Date:	08/06/18

Audited by:	JL
Date:	08/06/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 37752
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11A	12		
A	0.100	0.140		0.116	0.116	0.115	0.115		
B	0.100	0.140		0.121	0.121	0.121	0.121		
C	2.470	2.510		2.501	2.500	2.501	2.501		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.221	0.221	0.221	0.221		
F	1.313	1.343		1.322	1.323	1.323	1.324		
G	0.240	0.260		0.249	0.250	0.249	0.249		
H	0.615	0.685		0.645	0.645	0.645	0.645		
I	1.125	1.145		1.136	1.134	1.136	1.135		
J	0.990	1.010		0.998	0.999	0.999	0.999		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.110	0.110	0.110	0.110		
N	1.565	1.585		1.573	1.571	1.571	1.571		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.249	1.248		
Q	2.495	2.505		2.500	2.500	2.499	2.500		
R	0.490	0.510		0.505	0.503	0.503	0.504		
S	0.313	0.318		0.315	0.315	0.315	0.315		
T	2.495	2.505		2.500	2.498	2.499	2.499		
U	1.357	1.367		1.363	1.362	1.362	1.362		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.545	0.546	0.545	0.545		
X	1.674	1.684		1.679	1.680	1.679	1.679		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DTT</u>
Date: <u>08/06/18</u>

Audited by: <u>SL</u>
Date: <u>08/06/18</u>

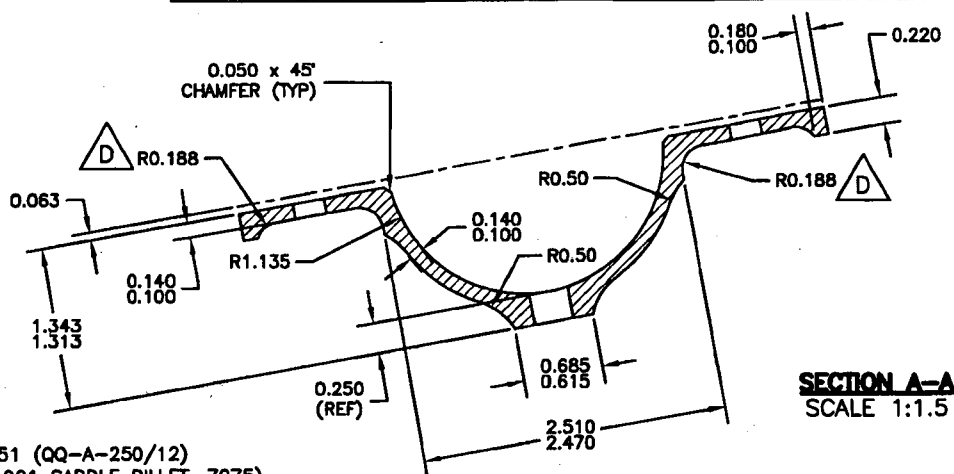
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

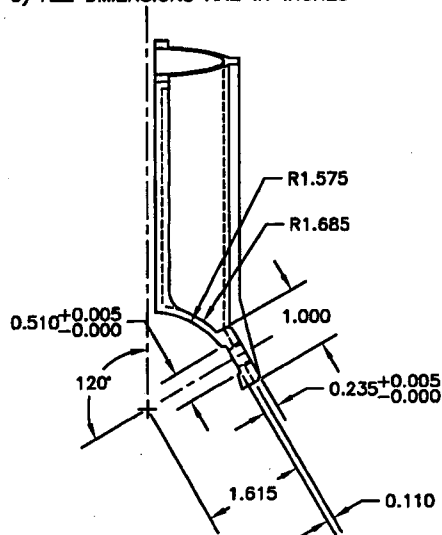
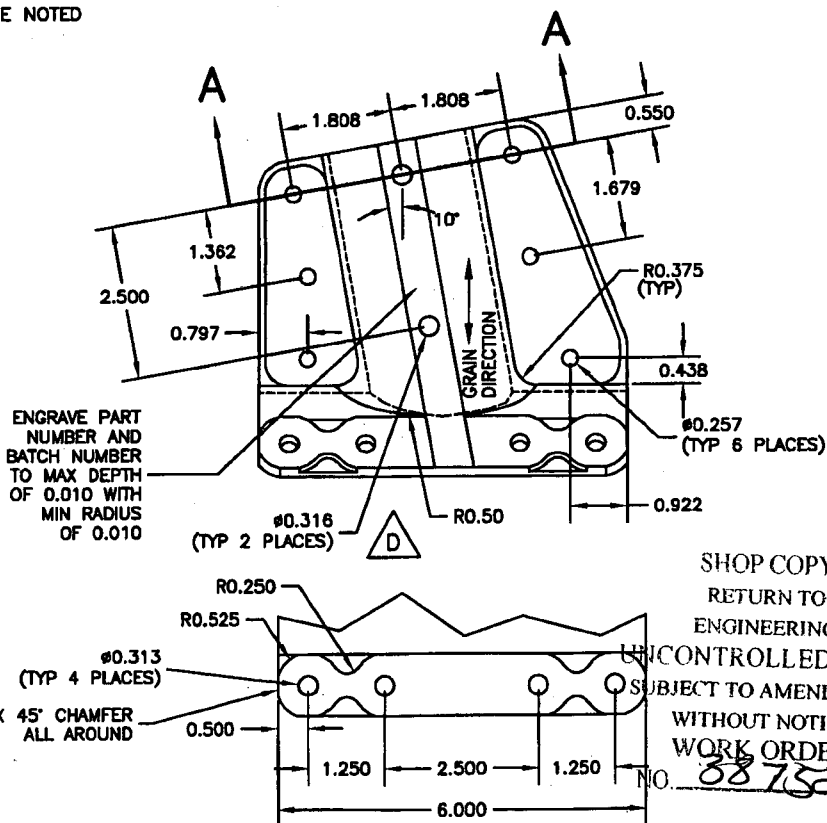
RELEASED

07.02.12

DESIGN	<i>PH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO.	REV. D
				D2666	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE FWD INSIDE HIGH	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313			

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 88752

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